

Date: Wednesday, 7/12/2006 3:23:03 PM
User: Kim Charlston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LOW FLOAT STEP ASS'Y RH AIRCRUISER COMPATIBLE
Job Number	: 27870A	Part Number	: D2356042
Estimate Number	: 11854	Drawing Number	: D2356 REV D/E
P.O. Number	:	Project Number	: N/A
This Issue	: 7/12/2006	Drawing Revision	: D/E E
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 8/15/2006 Qty: 7 Um: Each
Previous Run	:		
Written By	:		
Checked & Approved By	:		
Comment	: Est D 00.06.26 Removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	D2244116	Step Extrusion
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: +4 6x328216 Qty Part number Description Batch 1 D2244 Step Extrusion 323404
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE.1
		Comment: LARGE FABRICATION RESOURCE 1 Cut D2356-2 from D2244 extrusion as per Dwg D2356 using cutting table setup DT 8185-L Drill D2356-2 as per Dwg D2356 using Jig DT 8230 a.m 02.07.23 (6) b.e. 06.08.5 Bend per Dwg D2356 using Bend Program D2356.2D and Folio FT012 02.07.23 (6) b.e. 06.08.5 Deburr and bevel ends for welding a.m 07.07.23 (6) b.e. 07.07.23 (7) b.e. 07.07.23 (6)
3.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP
4.0	D267334	End Plate
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part number Description Batch 1 D2673-34 End Cap 3232404

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 27870A

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07/07/23	2.0	- 1 scrap. Step has a major kink in the side, from the raw extru- sion, i smooth kink did not remove during bending. - 1 step scrap, over bent. Operator error.	ASIAU2	Refile both and scrap and classify scrap parts.	EZ 7-7-23	Sp 07/07/23	ASIAU2	1 07/07/23

Part No: D2356-042 PAR #: N/A

Fault Category: Pass - LG

NCR: Yes No DQA: AA07.08.17
Date: 01.08.21
Date:

NOTE: Date & initial all entries

QA: N/C Closed: AA

Date: Wednesday, 7/12/2006 3:23:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW FLOAT STEP ASS'Y RH AIRCRUISER COMPATIBLE

Job Number: 27870A

Part Number: D2356042

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D28491 End Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

End Bracket

Pick:

Qty	Part number	Description	Batch
1	D2849-1	Bracket	39423

7/07/04/11

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and bracket as per Dwg D2356 using Jig DT 8093

Grind end cap weld flush Remove all sharp edges from weld on bracket

See sample DT 8245

7/01/04/25

7.0 QC5/9 WELD INSPECTION



Comment: WELD/WORK INSPECTION

8.0 D26431 Lo Skid Step LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lo Skid Step LH

Pick:

Qty	Part Number	Description	Batch
1	D2643-1	Lo-Step Leg Ass'y	39424 or 316928

7/07/04/26

9.0 D26432 LO SKID STEP RT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

LO SKID STEP RT

Pick:

Qty	Part Number	Description	Batch
12	MS20600AD4W3	Rivet	316929

7/07/04/26

10.0 MS20600AD4W3 Cherry Rivets



Comment: Qty.: 12.00000 Each(s)/Unit Total : 48.00000 Each(s)

Cherry Rivets

Pick:

Qty	Part Number	Description	Batch
12	MS20600AD4W3	Rivet	M18071

7/07/04/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Wednesday, 7/12/2006 3:23:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW FLOAT STEP ASS'Y RH AIRCRUISER COMPATIBLE

Job Number: 27870A

Part Number: D2356042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Rivet as per Dwg D2356

Mo 01.07.27 7

12.0

QC5

QC9 A

INSPECT WORK TO CURRENT STEP



QC5 En 02/07/20



Comment: INSPECT WORK TO CURRENT STEP

QC9 M 02/07/30 57



POWDER COATING



POWDER COATING

m 105068

7

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL/M-6 07-08-14

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



n/04/942



Comment: Wing Walk as per Dwg D2356 and QSI 005 4.4

Fx 07/08/14 7

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION AND WING WALK

En 07/08/15 7

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PP 27870 7/8/15 sq

7X1

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Mo 07.08.17

Job Completion



u 07.08.16

13.0A

Acid etch & abodine per QSI 005

a.m 07.07.26

A

BL/F 07-07-30

7.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



DESIGN KE	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>PH</i>	DRAWING NO. D2356	REV. E SHEET 1 OF 2
DATE 05.11.14		TITLE LOW FLOAT STEP ASSEMBLY	SCALE NTS

A	95.02.16	NEW ISSUE
B	97.05.22	END CAPS CHANGED
C	97.07.23	ADDED BUSHING AND FACING INFO
D	98.10.13	CHANGED TO BEND, D2849 REPLACES D2358 & D2359, INCORP. DEO 9084
E	05.11.14	UPDATE FINISHING NOTE

D2356 LOW FLOAT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY -041	QTY -042
D2356-041	Low Float Step Assembly (LH)	X	
D2356-042	Low Float Step Assembly (RH)		X
D2244-52.7	STEP EXTRUSION*	1	1
D2643-1	STEP LEG ASSEMBLY	1	1
D2643-2	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2849-1	END BRACKET	1	
D2849-2	END BRACKET		1
MS20600AD4W3	RIVETS	12	12

*cut per drawing

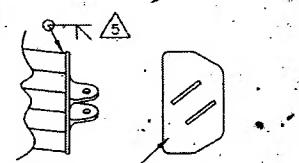
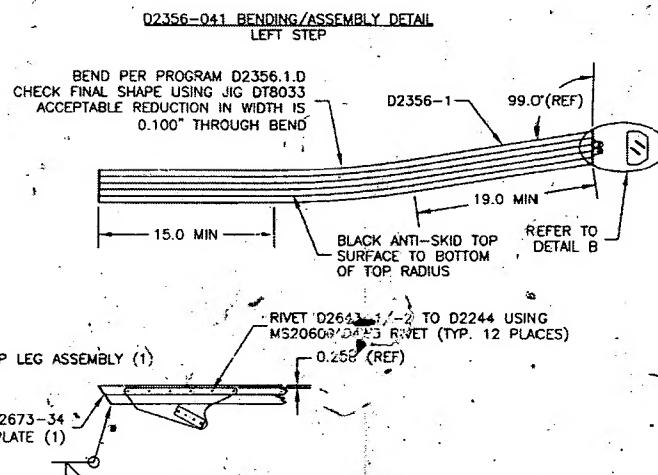
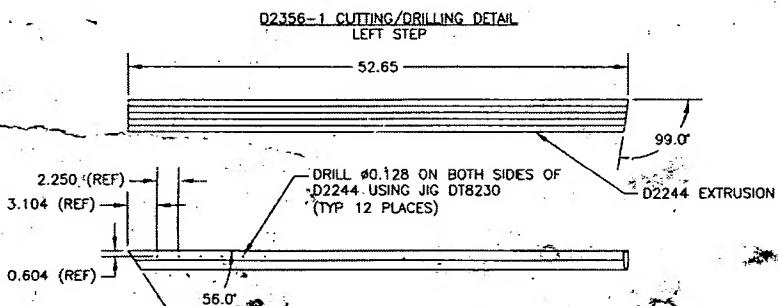
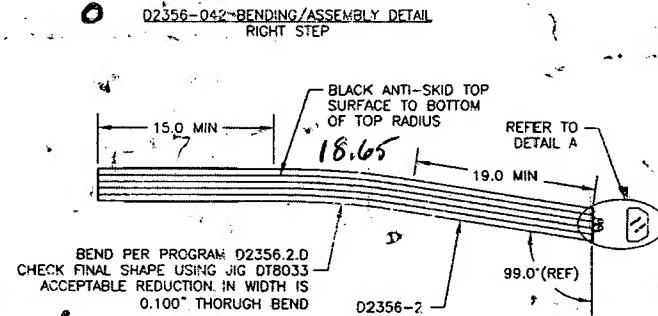
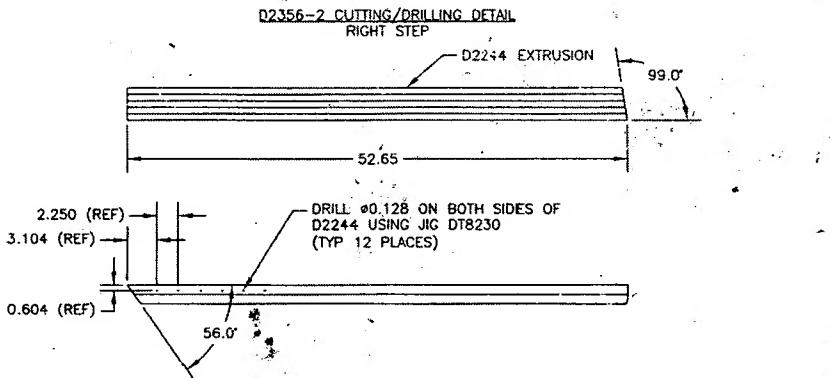
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *27870A*

RELEASED
05.11.28

Copyright © 1995 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.





UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
WITHOUT NOTICE
WORK ORDER
27/8/04
27/8/04
27/8/04

GENERAL NOTES

DETAIL B

1) WELD PER DART-QSI-004
SCALE: 1:4
2) FINISH: - CHEMICAL CONVERSION COAT PER DART-QSI-005-4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART-QSI-005-4.3
BLACK ANTI-SKID PAINT PER DART-QSI-005-4.4

3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART-QSI-018 UNLESS OTHERWISE NOTED

CAUTION D2244 EXTRUSION 0.075" X 45° BEFORE WELDING D2849-1 OR D2643-2 IN PLACE. DO NOT GRIND FLUSH.

COPYRIGHT © 1998 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN
DRAWN BY
B.W.
CHECKED
APPROVED
DATE
05.11.14

DART
DRAWING NO.
D2356
TITLE
LOW FLOAT STEP ASSEMBLY

RELEASED
05.11.28

REV. E
SHEET 2 OF 2
SCALE
1:12

